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D3914-041

Job Sheet 199708



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Due Date: 9/13/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	9/13/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		DAS
							Large Fab - 5		43
							Large Fab - 6		9-89
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	9/13/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	SEP 27 2019
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	9/13/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	SEP 27 2019
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

Plex 8/29/19 12:46 PM Dart.lajeunesse.marie

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	9/13/19	0.00 0.40		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
135 QC 3	1 pcs	9/13/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	9/13/19	0.00 0.80		Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	9/13/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	

BE 19-10-01

BE 19-10-01

BE 19-10-01

M 19-10-01

DAS
59
9-89DAS
15
9-89

					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
160	Packaging 3-1 - Stock - B4B	1	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	BE81940-01
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 -	
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170 QC 21 - SA	1 pcs	9/13/19	0.00 0.00	B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M/25890 1- assemble ribs, weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch: S209362 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

012052

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S200407
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	DAS S210864
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	43 S208655
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	9-00 S193147
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	S210636
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	S208015
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	3173801
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	1X S210776 1X S21130

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	41	0
	D3914-1	2	8	0
	D3914-7	2	10	0
	D4016-3	3	65	0
	D4018-5	9	11	0
	D4020-5	1	9	0
	D4021-3	1	25	0
	D4035-043	2	6	0

Part Specifications

Specifications could not be found.

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Date:

Entered:

Route update only

NCR No.

Job:

Part No.

DISPOSITION

Rework	Scrap	Use-as-is
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DEPARTMENT/PROCESS

Skid-tube		Cross tube
Machining		Small Fab
Large Fab		Finishing

Eng. (Non-AW)	
Prod. Eng. Coord.	
Rec./Store/Packaging	

Engineering	Water Jet	Supplier	Quality
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MRB (QSI042)

Sequence #:

QTY Affected :

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Root Cause

	Operator
	Manufacturing Process
	Equip/Tooling
	Handling/Preservation
	Material
	Product Improvement
	Process Improvement
	Human Factors

	Pressure/Forced
	Bending
	Crushing
	Cracks
	Crimp/Kink/Ripple
	Marks/Chatter
	Mislabelled

Other/Details:

Contamination
Misaligned/off center
BOM/Route
Broken/Damaged
Incomplete/Unfinished
Drill Holes
Fit/Function

Power Loss/Surge
Folio/Program
Grain Direction
Weld
Wrong Stock Pulled
Out of Sequence
Off-set/Set-up

Positioned Wrong
Outside Tolerance
Drawing
Finish
Part Lost/Missing
Misread